Conventional Milling Machine

Drill as per Dwg D3447Deburr

Work Orde Friday, January				*11(<u> </u>	•						Page 1
Item ID: Revision ID: Item Name:	D3447-5 Clevis			Accept	*N90) 004	010 0	N *	Setup	Start Stop	··· I VI	S1* S2*
Start Date: Required Date: Reference:	1/3/2014 1/31/2014	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust It Custon						ı w	
Approvals:	Process Plan	n:	Date: 14-01-03	7 Tooling: SPC (Y/N):		Date:			Run	Start Stop	^ \	R1* R2*
Sequence ID/ Work Center II		Operation 2 A Description		Set Up/ Run Hours	Tool		# Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										1
D3447	Rev	A										
1 \\n^ \\ Doosan Lathe		DOOSAN LATHE Memo Turn as per	Folio N/A & Dwg B67-4	0.00 0.00 3001Dwg Rev:				7				14/61/12
¹¹⁰ *11∩*		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				7				OAS 40 8-89
QC Quality Control		Memo		0.00					-			14/02/12
120		CONVENTIONAL MIL	LING MACHINE	0.00				~				lust
120		3.2		0.00						<i>B</i>		/14/01/2

TOD

DQA: (Stark	Date:	14/	2/11				2444105 / 1125	A T.F.			DART
QA Closed:	DD .	Date:	14-	2-11	WORK ORDER NON	-CC	NFOI	RMANÇE / UPD/		rk Order up	date only	AEROSPACE
Work Order:	110	603		_	DISPOSITION				AGAINST DEI	PARTMENT	PROCESS	
Part No.	D34	47-5			Rework Scrap Use-as-is Suspected Unapproved			Machining & S	Crosstube Small Fab Finishing omposite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root		CA	04	Desci	ription of work order update	l l	nitial ief Eng	Action		Sign & Date	Verification	QC Inspector
Cause Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	Date 14/01/12	Step ioO	Qty	Mî N Firs	or non-conformance All length of 3,747 iMal length is 3,750. That adjust or by .030. ormspr TMR	K	0.27	ACCEPTACIE. DISTALLE OF IS STILL PRESE	. edge : 1.5ed : 200	DAS 40 9-89 14/01/12	245 98 9-5 14/01/27	DAS 16 9:89 [4] [0] [7]
<u> </u>						FA	ULT CA	TEGORY				
Landing	Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple at n Strip in natter equence	e/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruc Misalia Mislab Misrea Off-set Out of	tion Incomplete/Unqua tions Incomplete/Uncl gned/off center eled d Calibration	lear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	່ Jwave/⊺ພ	ist in Tul	he		Fit/Function		Out of	Sequence				

Work Ord Friday, January				*11(<u> </u>	3*							Page 2
Item ID: Revision ID: Item Name: Start Date:	D3447-5 Clevis 1/3/2014	Start Qty: 6.00	*6*	Accept		900	040 D:	100)*	Setup	Start Stop	"IVI	S1* S2*
Required Date: Reference:	1/31/2014	Req'd Qty: 6.00	*6*			istomer:							
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):			ate:			Run	Start Stop	^IVI	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Г	Cool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
130 *130* QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00					_7	_	Y		/14/01/s
140 *1 4 1 * * QC Quality Control		QC8- Inspect parts - sec	ond check	0.00). _a	14/01	27				d _		08 08

0.00

0.00

F 76 141-28

150

150 HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

DQA:			Date:										TRACT
						WORK ORDER NON-	-CC	NFO	-				AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	
Work Orde	·r·					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
WOIR OIGC	'' -					Rework	ı		Skid-tube Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
	-				_	Use-as-is			noforming Finishing		1	e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composite			Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data] .						
Equip/Tooling	_												
Handling/Pre	႕												
Material													
Operator	_						l						
Offset/Setup							ļ						
Process	\dashv												
Supplier													
Training													,
Transport Unapproved													
Опаррточец				<u> </u>	<u> </u>		FΔI	ULT CA	TEGORY		<u>. </u>		
Landii	nø G	iear				General		<u> </u>					
		Bending				Bend	Г	Folio/F	Program	Γ	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		T	Over/Under		Set-up
		Cracks				Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorre	 	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs				Contamination		4 '	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	П	Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	,
		Heat Trea	ıt			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
}		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence		•		

Work Orde Friday, January				*11	0603*				3.05			Page	: 3
Item ID: Revision ID: Item Name:	D3447-5			Accept	*N900)040	100)*	_	Start Stop	*N.		
Start Date: Required Date: Reference:	1/3/2014 1/31/2014	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:								
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):)ate:)ate:		1		Start Stop	*NF	R1* R2*	,
Sequence ID/ Work Center II 160 . *160* Powdercoat		Operation Description Green Sandtex(Ref:4.3.5 Memo Mask 0.875' TEMPERAT	round sectionSTART TIM	Set Up/ Run Hours 0.00 0.00 ME: H TIME:	Tool ID . O OVEN	Tool #	Plan Code	Accept Qty	Reject Qty	N	leject lumber	Insp. Stamp	DA Se
170 *170* QC		QC3- Inspect Part Finish Memo		0.00 DAS 0.00 27 9 89	i) na			7	_				

Identify as per dwg & Stock Location: Mezz. 2 0.00

120 Packaging

Quality Control

Memo

 $7 \times \frac{28}{9.89} /4-0/-30$

Packaging

180

0.00

DQA:			Date:										TRAGG
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAI	NST DE	PARTMENT	PROCESS	
WOIK OIG	٠					Rework	1		Skid-tube Crosst	ube	1	Water Jet	Engineering
Part N	No.	_				Scrap		1	Machining Small		Pro	d. Eng. Coor.	Quality
NCR I	No.					Use-as-is Suspected Unapproved		Thern	noforming Finish Large Fab Compo		Rec/Stor	e/Packaging Supplier	Other
Root					Desci	iption of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material							١.						
Operator							1	*					
Offset/Setup													
Process													
Supplier													
Training					ł								
Transport													
Unapproved					1								
							FA	ULT CA	TEGORY			***	
Landi	ng (Gear				General	_	_		_	-		_
		Bending				Bend	L	Folio/F	Program		Outside Dim	ensions	Pressure/Forced
ļ	<u> </u>	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	cí	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Unqualified		Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
i		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	-
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
1		 Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence				

Work Orde Friday, January				*11(1603*							Page	4
Item ID: Revision ID: Item Name:	D3447-5 Clevis			Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	·· [V]	S1* S2*	
Start Date: Required Date: Reference:	1/3/2014 1/31/2014	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1 Customer:	D:							
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	^IVI	R1* R2*	
Sequence ID/ Work Center II)	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Qt	y	Reject Number	Insp. Stamp	
*1 QC QC Quality Control		Memo		0.00	• 3			MI	<u>,5</u> -		<u> </u>)>	-

W 14-01-30

DQA:			Date:						_				TRAGE
						WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	ar.					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
WOIK OIG	-				_	Rework			Skid-tube Crosstube	Г]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	-		· · · · · ·			Use-as-is		Therr	noforming Finishing		Rec/Stor	e/Packaging	Other
NCR f	No.	-				Suspected Unapproved			Large Fab Composite]	Supplier	
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data				•								·	
Equip/Tooling				1					ŧ				
Handling/Pre	Ш												
Material	Ш			ļ			/	7					
Operator							`						
Offset/Setup			1										
Process									<u> </u>				
Supplier							l						
Training													
Transport							1						:
Unapproved				<u> </u>							L	<u> </u>	
						· · · · · · · · · · · · · · · · · · ·	FA	ULT CA	TEGORY				
Landi	ng (1				General	_	1		_	7	_	- .
		Bending			_	Bend	<u> </u>	1	Program	L	Outside Dim		Pressure/Forced
		Centre No	ot Concei	ntric		BOM/Route		Grain		<u></u>	Over/Under	<u> </u>	Set-up
	<u></u>	Cracks			_	Broken/Damage/Defect	L	Hardwa		L	Part Incorre	-	Temperature/Cure
		Crimp/Kir	nk/Ripple	e/Wave		Burrs	_	- '	tion Incomplete/Unqualified	L	Part Lost/M	issing	Weld
		Cuffs				Contamination	L	-	tions Incomplete/Unclear		Part Moved	L.	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink		-1	gned/off center	L	Positioned \		- .
]		Heat Trea	at			Cut Too Short	_	Mislab			Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea					
1		Marks/Ch	natter			Drill Holes		Off-set					
	L	Turning S				Finish		=	Calibration				
ļ		Wave/Tw	ist in Tul	be		Fit/Function	1	Out of	Sequence				

Friday, January 03, 2014 10:08:43 AM

Page 1

Work Order ID:

110603

Parent Item:

D3447-5

Parent Item Name:

Clevis

Start Date: 1/3/2014

Required Date: 1/31/2014

Start Qty: 6.00

Required Qty: 6.00

Comments:

AA05.08.26New issueKJ/JLM

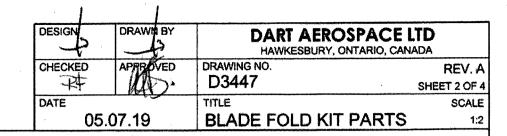
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

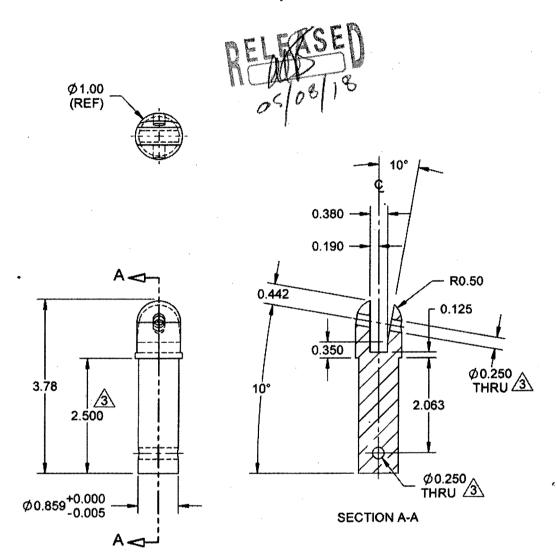
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000		Purchased	No			100	f	58.0000	0.3167	3			NΑ
ROUND BAR 1.00"										·		1/01/1	4
				Location		Loc Oty	<u>Lo</u>	c Code					9-8
				MAT013		58							
				. → m12	6593	58				<u> </u>			

٠,

DQA:			Date:										TRAG
			. .			WORK ORDER NON-	-CC	ONFO		14/-	anti Ondon	data anb.	AEROSPACE
QA Closed:			Date:				-			VVC	ork Order up	date only	
Work Orde	r:					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS	
	-				_	Rework			Skid-tube Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fab			d. Eng. Coor.	Quality
NCR N	lo.					Use-as-is Suspected Unapproved		Thern	noforming Finishing Large Fab Composite		Rec/Stor	e/Packaging Supplier	Other
Root					Desci	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data		٠											
Equip/Tooling													
Handling/Pre	\Box												•
Material								jeda S					
Operator						·	-	,7					
Offset/Setup			2										
Process	\Box												
Supplier						•							
Training						•			· ·			: -	
Transport							Į		ļ		,		
Unapproved													
							FA	ULT CA	TEGORY				
Landi	_	l			_	General		1		_	7 .	_	-
		Bending	•		\perp	Bend	_	1	Program		Outside Dim	<u> </u>	Pressure/Forced
		Centre No	ot Concer	ntric	_	BOM/Route		Grain		_	Over/Under	-	Set-up
		Cracks			\vdash	Broken/Damage/Defect		Hardwa	•	L	Part Incorre		Temperature/Cure
		Crimp/Kir	nk/Ripple	:/Wave	<u> </u>	Burrs		4 '	tion Incomplete/Unqualified	_	Part Lost/Mi	ssing	Weld
		Cuffs			<u> </u>	Contamination	L	4	tions Incomplete/Unclear	L	Part Moved		Wrong Stock Pulled
	L	Crushing			L	Countersink	\vdash	- 1	gned/off center	\vdash	Positioned V		¬₌
	<u> </u>	Heat Trea				Cut Too Short		Mislab		<u> </u>	Power Loss/	Surge	Other
	_	Inspectio	•	Tube		Drawing	_	Misrea					
	<u> </u>	Marks/Ch			<u> </u>	Drill Holes		Off-set					
	<u> </u>	Turning S	•		\vdash	Finish	<u> </u>	4	Calibration				
		Wave/Tw	ist in Tub	ре		Fit/Function		Out of	Sequence				







D3447-5 CLEVIS SUPERSEDES PREMIER P/N B67-43001-99

NOTES:

1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)

2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DQA:			Date:												୬ T
						WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE				A E R O S P	ACE.
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEI	PARTMENT	/PROCESS		
	•				_	Rework	1		Skid-tube	Crosstube			Water Jet	Engineering	
Part N	lo.			•		Scrap		ا	Machining	Small Fab		Pro	d. Eng. Coor.	Quality	
	•					Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging	Other	
NCR N	10.				<u> </u>	Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desc	ription of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	ł	ief Eng	Desc	ription		Date	Verification	QC Inspect	tor
Design															
Doc/Data															
Equip/Tooling													-		
Handling/Pre]						ļ								
Material															
Operator															
Offset/Setup															
Process							-								
Supplier															
Training															
Transport													-		
Unapproved							L.		<u> </u>			<u> </u>			
							FA	ULT CA	regory						,
Landi	_	3				General	_]_ :: /=				1	. г	¬-, ,,,	
	Н	Bending			-	Bend BOM/Bowks	\vdash	1	rogram		_	Outside Dim	<u> </u>	Pressure/Force	a
		Centre No	ot Concer	ntric	-	BOM/Route	-	Grain Hardwa			┝	Over/Under Part Incorre	-	Set-up Temperature/C	`uro
ļ,		Crime /Vir	ak/Dimala	Maria	-	Broken/Damage/Defect	-	4		Inqualified	⊢	Part Lost/Mi	-	Weld	ure
	H	Crimp/Kir Cuffs	ık/kibbie	y wave	\vdash	Burrs Contamination	\vdash	4 '	ion Incomplete/U tions Incomplete/	·	-	Part Moved	SILIE	Wrong Stock Pu	ulled
		Crushing			-	Countersink	\vdash	4	ned/off center			Positioned V	L Vrong	VVIOLIS SLOCK PL	AIICU
		Heat Trea	ıt		-	Cut Too Short	-	Mislabe	~		-	Power Loss/		Other	
	\vdash	Inspection		Tube		Drawing	\vdash	Misrea			Щ	1. 0 1.033/		100,101	
		Marks/Ch	•			Drill Holes	\vdash	Off-set							
		Turning S				Finish		4	Calibration						
		Wave/Tw	•			Fit/Function		4	Sequence						

DART AEROSPACE LTD	Work Order:	116003
Description: Clevis	Part Number:	D3447-5
Inspection Dwg: D3447 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments				
3.78	+/-0.030	3,780			VEM	840-12				
2.500	+/-0.010	2 498			'4	٠,				
Ø0.859	+0.000/-0.005	. 856	/		μ	(1				
10°	+/-0.5°	10°			14.18-06	SOUARE>				
0.380	+/-0.010	.376	/		11	<i>i</i> ,				
0.190	+/-0.010	.188	/		14	n				
0.442	+/-0.010	0,439	/		MJP-04	Vem				
R0.50	+/-0.030	.500	/		Rad G					
0.125	+/-0.010	. 125	1		VEW	P4D-12				
0.350	+/-0.010	0,360	/		111-04	Vem				
Ø0.250	+0.005/-0.001	.250	/		V6NU	940-12				
10°	+/-0.5°	10.			MJP-06	SQUARES				
2.063	+/-0.010	2,062	V		VEW	P40-12				
Ø0.250	+0.005/-0.001	0,252	/_	, ,	MIPOY	Vern				
1.00	+/-0.030	, 990			UEM	PL10-12				
V *-de-seri			,							
, <u>,</u>		<u> </u>								
	DAS		1							

	OAS				
Measured by:	40 /110	Audited by:	13.0 DAG	Prototype Approval:	N/A
Date:	14/01/12 18/0	/ Date:	14/01/27 89	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.07.24	New Issue	KJ/DD OF	78

OQA: Date:						. MODE ODDED NON CONFORMANCE / LIDDATE								DART	
QA Closed: Date:						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WOIK OIGE	-1.				— i	Rework			Skid-tube	7	Water Jet	7 6	ngineering		
Part N	lo.					Scrap			Machining	Crosstube Small Fab	Prod. Eng. Coor.			Quality	
NCR N	- ا lo.					Use-as-is Suspected Unapproved			Finishing Composite	Rec/Store/Packaging Supplier			Other		
Root		·			Desci	ription of work order update		nitial	Act	ion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	\perp	QC Inspector	
Design Doc/Data												÷			
Equip/Tooling	\neg						1		,						
Handling/Pre						•									
Material					·										
Operator															
Offset/Setup												. ·		•	
Process															
Supplier			İ												
Training						•							1		
Transport												*			
Unapproved					<u> </u>	· · · · · · · · · · · · · · · · · · ·	ł		<u> </u>				_		
						<u></u>	FA	ULT CA	TEGORY			·			
Landi	ng (_	General	_	1		_				4	
	Bending					Bend			folio/Program		Outside Dimensions			essure/Forced	
		Centre Not Concentric			<u> </u>	BOM/Route	<u></u>	Grain	Ļ		Over/Under tolerance		_	et-up	
	Cracks				\vdash	Broken/Damage/Defect	<u> </u>	Hardware			Part Incorrect		—	mperature/Cure	
	Crimp/Kink/Ripple/Wave			e/Wave	<u> </u>	Burrs		1	on Incomplete/Unqualified		Part Lost/Missing			eld	
	Cuffs				<u> </u>	Contamination	—	4	ions Incomplete/Unclear		Part Moved		_J ^w	rong Stock Pulled	
 	Crushing				<u> </u>	Countersink	-	1	gned/off center	-	Positioned Wrong		٦.,	hor	
	Heat Treat				<u> </u>	Cut Too Short	_	Mislabeled		L	Power Loss,	surge [lot	ther	
	Inspection Strip in Tube			<u> </u>	Drawing	\vdash	Misrea								
		Marks/Ch			-	Drill Holes	\vdash	Off-set							
	Turning Sequence				-	Finish	<u></u>	4	Calibration			· 			
ł	Wave/Twist in Tube					Fit/Function		Out of	Sequence				_		